

**MANUFACTURE OF ACCESSORY ENAMEL PANEL**

Patent Number: JP1149976  
Publication date: 1989-06-13  
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Requested Patent: ☐ JP1149976  
Application Number: JP19870307826 19871204  
Priority Number(s):  
IPC Classification: C23D5/00  
EC Classification:  
Equivalents: JP2519274B2

**Abstract**

**PURPOSE:** To produce an accessory enamel panel capable of surely holding a required shape by connecting the end parts of the accessory panel with each other by a stay being same material as the panel and then calcining, cooling it and thereafter removing this stay.

**CONSTITUTION:** For example, in an accessory panel 1 consisting of a steel sheet for enamel in which flanges 2 folded back to the peripheral edge parts of two planes 3, 4 are formed and the cross-section is curved to a chevron-shape, the end parts are connected by stays 5 being same material as the panel with each other. This connection is sufficiently performed by spot welding. Then, this accessory panel 1 is hung with a hanger, etc., glazed and thereafter calcined and baking is performed. Thereby, distortion due to deformation and thermal expansion difference of the accessory panel is prevented and calcination is completed while holding an accurate shape. Then, after cooling, the accessory enamel panel surely held with the aimed shape is obtained by removing the above-mentioned stays 5.

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